Page 1

Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name: Replacement Skidtube

Required Date: 2/26/10

2/10/10

Start Qty: 1.00

Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Date: 10-2-(C Tooling:

Date:

Run Start

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

Operation Description Set Up/ **Run Hours**

Draw Number

Plan Rev. Code

Accept Qty

Reject Qty

Reject Stamp Number

Draw Nbr

Revision Nbr

QC:

: D2580

Rev D

100

110

DOCUMENT CONTROL

Memo

0.00

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

0.00

CNC Bend 1

BENDING MACHINE - SKIDTUBES

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

M10/2/11

Dart Aerosp	pace Ltd
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W/O:	•		\^	ORK ORDER CHANG	EC				-
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				·.				. Tod Wg.	
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQA	\:	Date:	
					QA: N/C Closed: Date:				
NCR:				DER NON-CONFORMA					
DATE	STED	Description of NC		Section B Verif			Approval	Approval	
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
					!				
							:		
	1								•

Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

Required Date: 2/26/10

2/10/10

Start Qty: 1.00

Operation

Description

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Process Plan: Approvals:

Tooling:

Set Up/

0.00

0.00

Run Hours

Date: Date:

Start Run

Stop



QC:

SPC (Y/N): Date:

Draw

Number

Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Sequence ID/ Work Center ID

120

Skidtubes Skidtubes

Memo

1- Deburr ends

QC5- Inspect part completeness to step on W/O

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

Date:

130

Memo

0.00

0.00

Quality Control

Dart Aerospace L	Ltd
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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PROCEDURE CHANGE			Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	'Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	NCR: Y	es N	o DQ /	A:	Date:	
				Disposition: QA: N/C Closed: Date						
NCR:			WORK ORE	ER NON-CONFORMA	NCE (N	CR)				
DATE	STEP	Description of NC			Section B			ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section		Chief Eng	QC Inspector
		<u>.</u>								



Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date: Required Date: 2/26/10

2/10/10

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/

Operation **Description Work Center ID**

QC:

Set Up/ **Run Hours** Draw Number Draw Rev.

Plan Code

Reject Accept Qty **Qty**

Reject

Insp. Number Stamp

140

Skidtubes

Skidtubes

Memo

0.00

0.00

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill A/RDID Aluminum Rod m//3207

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64". adjust stopper not to hit web.Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

10-2-23

	-								
W/O:			WC	RK ORDER CHANG	GES	· · · · · · · · · · · · · · · · · · ·	- 11.	·····	
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	'Approval QC Inspector
				*					
Part No		PAR #:							
	Resolution: Disposition:							Date: _	
NCR:			WORK ORDE	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC					cation	Approval	Approvai
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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Item ID:

D205-634-041

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date: Required Date: 2/26/10

2/10/10

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Tooling: Date:

Date:

Start

Stop

Stop

QC:

Date:

SPC (Y/N):

Set Up/

Draw Number

Draw Rev.

Plan Accept Qty Code

Reject Qty

Run

Reject Insp. Number Stamp

Sequence ID/ Work Center ID

150

Quality Control

Operation **Description**

QC10- Inspect visual per QSI004- ground welds

Memo

Run Hours

4 Worls

0.00

160

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

170

HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

Memo

PAR 09-043.

Dart Aerospace	e Ltd
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W/O:			W	ORK ORDER CHAN	GES	·			
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQA	\:	 Date:	
Resolution: Disposition:									
NCR:			WORK ORI	DER NON-CONFORM	IANCE (NCR)			
DATE	STEP	Description of NC			ction B	Verification		Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
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		•						·	
							·		

Work Order ID 56137

February 10, 2010 2:56:41 PM



Page 5

Item ID:

D205-634-041

Accept



Setup Start



Revision ID:

Start Date:

Replacement Skidtube Item Name:

> 2/10/10 Start Oty: 1.00

> > **Reg'd Oty:** 1.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Required Date: 2/26/10

Process Plan:

Date:

Tooling:

Date:

Start

Stop

Date:

SPC (Y/N):

Set Up/

Date:

Draw

Rev.

Plan

Code

Stop

Reject

Qty

Run

Number Stamp

Insp.

Reject

Sequence ID/ Work Center ID

180

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

人人113170

Run Hours 0.00

0.00

M. 10/03/02

Accept

Qty

START TIME: OVEN TEMPERATURE: 3209 FINISH TIME:

190

Memo

QC3- Inspect Part Finish

Memo

BK 10-3-2

Quality Control

W/O:			W	ORK ORDER CHANG	GES			
DATE STEP		PRO	OCEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	'Approval QC Inspector
		N. Francisco						
Dort No.	_	DAD #					_	
			#:					
NCR:				DER NON-CONFORM				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	sign &	Verification Section C	Approval Chief Eng	Approval QC Inspector
								-
			`					
		•						1

Work Order ID 56137

February 10, 2010 2:56:41 PM

Item ID:

D205-634-041

Accept



Setup Start



Revision ID: Item Name:

Start Date:

Replacement Skidtube

2/10/10

Start Oty: 1.00

Req'd Qty: 1.00

Operation

Description



Date:

Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan: QC: ____

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Draw

Rev.

Date:

Reject

Qty

Run

Accept

Qty

Start

Stop

Reject

Number

Stop

Insp.

Stamp

Sequence ID/

Work Center ID

Required Date: 2/26/10

200

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of

Sikaflex on insert holes before installing yearnlates A/R THE Sikaflex-291 E//0345EI

Sikaflex expire date: _

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with

Sikaflex. Clean excess adhesive

A/R 🛘 🖺 Sikaflex-291 🗎

Sikaflex expire date:

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: //3462

0.00

bl 10-03-2 0

Plan

Code

Dart Aerospa	ace Ltd
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W/O:			W	ORK ORDER CHAN	GES			·	
DATE	STEP	PRO	PROCEDURE CHANGE			Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		•							
				Fault Category: NCR: Yes No DQA:					
	R	esolution:	Disposition: QA: N/C Closed: Date:						
NCR:		,	WORK ORD	ER NON-CONFORM	IANCE (NCF	R)			
DATE	STEP	Description of NC Section A	Initial	Action Description	ction B Sign 8	Verification C		Approval QC Inspector	
		<u> </u>	Chief Eng	Chief Eng	Date	0001101110		do mopostor	
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								-	

Work Order ID 56137 February 10, 2010 2:56:41 PM



Page 7

Item ID:

D205-634-041

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

Required Date: 2/26/10

2/10/10

QC:

Start Qty: 1.00

Reg'd Oty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date: **Tooling:** Date: _____

Stop

[0 143/8 O

Start

Stop



Sequence ID/

Work Center ID

Set Up/ Run Hours Draw Number Draw Rev.

Date:

Plan Accept Qty Code

Reject Qty

Run

Reject Number Stamp

Insp.

210

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

0.00

SPC (Y/N):

0.00

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for

Foreign objects per QSI 024

220

230

Packaging

Packaging

Memo

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location: PPP Rev:

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

10/03/1194 MF 10-3-5

Dart Aerospace	Ltd
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W/O:			V	VORK ORDER CHANG	ES			
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
**	•							
		**						
Part No	:	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQA:	Date: _	
Resolution:			Disposit	ion:	_ QA: N/C CI	osed:	Date:	
NCR:		V	VORK OR	DER NON-CONFORMA	ANCE (NCF	R)		
DATE	STEP	Description of NC	In it is a	Corrective Action Sec		Verification	Approval	Approval
<u> </u>		Section A	Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C	Chief Eng	QC Inspector
	ŀ							
							,	

Picklist Print

February 10, 2010 2:56:46 PM

Work Order ID: 56137

D205-634-041

Parent Item Name:

Replacement Skidtube

Comments:

Parent Item:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets

JLM

Start Date: 2/10/10

Start Qty: 1.00

Required Date: 2/26/10

Required Qty: 1.00

Replacement Mfg/ Bin Primary Last Route Unit of Qty on Remaining Qty Component Item ID/

D2580-1

Manufactured No 110

Each

5.0000

1.0000

Date Status

205 Skidtube bent detail

Warehouse

Loc Oty

Loc Code

Location Main Warehouse

LG



D2576-3

Manufactured

140

Each

141.0000 1.0000



Step (maching detail)

Warehouse	Loc Oty	Loc Code
Location		
Main Warehouse		
ST	141	
46661	94	
52215	47	

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	'Approval QC Inspector	
Part No		PAR #:								
	Resolution: Disposition:									
NCR:			WORK ORE	DER NON-CONFORMA	ANCE (NCR)	<i>y</i>			
DATE	STEP	Description of NC						Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	Section C	Section C	Chief Eng	QC Inspector
									-	

Work Order ID: 56137

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev:N□02.08.28⊔FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 2/10/10

Required Date: 2/26/10

Start Oty: 1.00

Required Oty: 1.00

Component Item ID/

D2579

Replacement Mfg/ Manufactured

Bin Primary No

Last

Route 140

Unit of Each

Qty on Remaining

147.0000 20.0000

Qty

Date Status

		11881		18818	•
Crossl	holf	Sn	ace	r	

Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			•
LG	25		
51525 -	4 '	, ·.	
53780	3		
54543	18		
Main Warehouse			
ST	122		
43988	4		
46434	4		
46956	2		
47797	9		
48272	2		
51314	71		
51315	30		

B 56145

BE 10/02/14

Dart Aerospace I	Ltd
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W/O:			W	ORK ORDER CHANG	ES						
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
	:										
Part No	:	PAR #:	_ NCR: Yes	No DQ	A :	Date:					
	R	esolution:	Disposition:			QA: N/C Closed: Da					
NCR:		V	WORK ORI	DER NON-CONFORMA	NCE (NC	R)		-			
DATE S	STEP	Description of NC	Initial	on B Sign	Verific		Approval	Approval			
	<u> </u>	Section A	Chief Eng	Action Description Chief Eng	Date		on C	Chief Eng	QC Inspector		
							, , , , , , , , , , , , , , , , , , , ,				

Work Order ID: 56137

Parent Item:

D205-634-041

Parent Item Name: Replacement Skidtube

Comments:

IPP Rev:N∷02.08.28 ☐ FP was QC5 in Step 27; Added QC5 to Step 30 ☐ KJ

IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/

D2855

Replacement Mfg/ Manufactured

Purchased

Bin Primary No

No

Last

Route 200

Unit of Each

Qty on 151.0000 1.0000

Remaining

Qty

Date Status

Warehou <u>se</u>	Loc Qty	Loc Code
Location		
Main Warehouse		
ST026	151	
50513	1	•
50770	1	

50770 51539 53791

110 200 Each

39

1,773.000 2.0000

AN3-5A

Bolt

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1773	
100188	188	
105057	1585	

2 fel 10-3-2

Dart Aerospace L	.ta
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			****					. 100 mg.	
									
Part No			PAR #: Fault Category:			NCR: Yes No DQA:			
	Re	Resolution: Disposition:			QA: N/C Closed: Date:				
NCR:		V	VORK OR	DER NON-CONFORMA	ANCE (NC	R)			
DATE STEP		Description of NC	of NC Corrective Action		ection B Verificatio			Approval A	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspector
		, , , , , , , , , , , , , , , , , , , ,							

Work Order ID: 56137

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ Comments:

IPP Rev:P 07-07-09

IPP Rev. O 06.02.28 Added paperwork

SS Wearplates & Gaskets

Start Date: 2/10/10

Start Qty: 1.00

Required Date: 2/26/10

Required Qty: 1.00

Component Item ID/ AN960JD10L

Replacement Mfg/

Purchased

Primary Bin No

Last

112772

113238

Route 200

Unit of Each

Qty on Remaining 3,459.000 2.0000

Qty

Date

Status

Washer

Loc Qty Loc Code Warehouse Location Main Warehouse 3459 ST101291 16 105793 49 110985 3394

Each

11 759

200

986.0000 50.0000

2 1/10-3-2

ALS7-1032-130 Purchased

Insert

ALS4-1032-130

No

Loc Qty Loc Code Warehouse Location Main Warehouse ST /10511 986 108606 52 111529 130 111779 34

50. BR 10-3-2

W/O:			WC	ORK ORDER CHANG	ES		····			
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							•			
Part No		PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA	\:	Date:		
					_ QA: N/C Closed: Date:					
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCF	R)				
2475	CTED	Description of NC Section A	Corrective Action Section B			Verific	ation	Approval	Approval	
DATE	SIEP		Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector	
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							į			

Work Order ID: 56137

Parent Item:

D205-634-041

Parent Item Name: Comments:

Replacement Skidtube

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Purchased

Replacement Mfg/

No

Bin Primary

Last

Route 200

Unit of Each

Qty on Remaining 1,263.000 50.0000

Start Date: 2/10/10

Start Qty: 1.00

Qty

Date

Required Date: 2/26/10

Required Qty: 1.00

Status

Component Item ID/ AN3C4A

BOLT	

Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse			
ST	1263		
112314	13		
112720	12		
112724	3		
112829	1		
112991	2		
113121	64		
113226	344		
113422	124		
113644 🗸	500		30 Dt 10-3-2.
113749	200		
	200 Each	388.0000 50.0000	

AN960C10L

washer

Purchased

No

NAS/149C0332R

<u>Warehouse</u>	Loc Oty	Loc Code	
Location			
OFFSHORE 10000			
FG [[3208	100		_50, DK 10-32
103585	100		
Main Warehouse			
ST	288		
112116	128		
112612	160		

	•								
W/O:			V	ORK ORDER CHAN	IGES	· · · · · · · · · · · · · · · · · · ·			
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	tegory:	NCR: Ye	s No DQ	A:	Date: _	
	Res	olution:	Dispositi	on:	QA: N/C	Closed:		Date: _	
NCR:		·	WORK ORI	DER NON-CONFORM	MANCE (NO	R)			
DATE	STEP	Description of NC		Corrective Action Section B			- Verification A		Approval
		Section A	Initial Chief Eng			Sign & Section C		Chief Eng	QC Inspector
									-
				_					

Work Order ID: 56137

Parent Item:

Comments:

D205-634-041

Parent Item Name:

Replacement Skidtube

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets

Manufactured

JLM

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 1.00

Required Qty: 1.00

Unit of Qty on Remaining Qty Date Bin Primary Route Component Item ID/ Replacement Mfg/ Last Status 200 83.0000 1.0000 D3566-13 No Each Manufactured

Gasket

Warehouse	Loc Qty	Loc Cod	<u>e</u>	
Location				
Main Warehouse				
FP ,	81			
53461	81			1 /2 10-3-2
Main Warehouse				
ST	2			
45717	1			
50265	1			
	200 E	ach 34.0000	1.0000	

D3566-5

Gasket

Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			4.0
FP19 /	30		1 BK10-3-2
55026	18		1 DK 10-5 A
55335	12		
Main Warehouse			
ST	4		
36113	1		
46186	1		
47318	1		
51260	1		

Dart Aerospace	Ltd
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	•									
W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					,					
Part No	:	PAR #:	Fault Cate	egory:	NCR:	Yes N	No DQ	A:	Date: _	
			olution: QA: N							
NCR:		,	WORK ORE	DER NON-CONFORMA	ANCE ((NCR))			
DATE	CTED	Description of NC Corrective Action			on Section B			cation	ion Approval Ap	
DATE	STEP	Section A	Initial Chief Eng			Sign & Section C			Chief Eng	Approval QC Inspector

Work Order ID: 56137

D205-634-041

Parent Item Name:

Comments:

Parent Item:

Replacement Skidtube

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Manufactured

No

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 1.00

Required Qty: 1.00

Qty on Remaining Qty Date Unit of Replacement Mfg/ Bin Primary Last Route Component Item ID/ Status 39.0000 2.0000 200 Each No D3566-1 Manufactured

Gasket

Warehouse	Loc	Oty	Loc Code		
Location					
Main Warehouse					
FP		34			
52512		3			
54480		1			
55011		3			2 BK 10-3-2
55320		27			2 BK 10-5-2
Main Warehouse					
ST		5 .			
46349		1			
51218		1			
51259		3			 .
	200	Each	5.0000	1.0000	

D3564-11

Wearshoe

Warehouse	Loc Qty	Loc Code		
Location				
Main Warehouse			/	BK 10-3-2
FP19 55332	3			DETOSA
52125	3			
Main Warehouse				
ST	2			
45823	1			
50112	1			

	-								
W/O:			W	ORK ORDER CHANGI	ES	-		·- ·-	
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						<u>.</u> . <u></u>			
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	\:	_ Date: _	
		solution:							
NCR:		,	WORK ORD	ER NON-CONFORMA	NCE (NCR))		, <u> </u>	
DATE	STEP	Description of NC	Description of NC Corrective Action		Section B Verific			tion Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	

Picklist Print

Page 8

February 10, 2010 2:56:46 PM

Work Order ID: 56137

Parent Item:

Comments:

D205-634-041

Parent Item Name:

Replacement Skidtube

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Manufactured

Manufactured

Start Date: 2/10/10

Required Date: 2/26/10

Date

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D3564-13

Replacement Mfg/

Bin No

Primary

Last

Route 200

Unit of Each

Qty on 23.0000

Loc Code

Remaining 1.0000

Qty

Status

Wearshoe

<u>Warehouse</u>	Loc Qty				
Location					
Main Warehouse					
FP17 /	11				
51611	11				
Main Warehouse					
ST .	12				
45409	2				
46495	10				
	200 Eac	ch			

14.0000 1.0000

Wearshoe

D3564-9

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP19	12	
55025	12	
Main Warehouse		
ST	2	
44659	1	
45825	1	

BR10-3-2

The 10-3-2

W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	*Approval QC Inspector
Dort No.									
Part No		PAR #:							
	Hes	solution:						Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR	(1)			
DATE	STEP	Description of NC	Description of NC Corrective Action		Vorific			ion Approval App	Approval
	OIL.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector

Work Order ID: 56137

Parent Item:

Component Item ID/

D205-634-041

Parent Item Name:

Comments:

Replacement Skidtube

IPP Rev:N∷02.08.28⊞FP was QC5 in Step 27; Added QC5 to Step 30□KJ IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Replacement Mfg/ Manufactured

No

Bin Primary

Last

Route 200

Unit of Each

Qty on 44.0000

Remaining 1.0000

Start Date: 2/10/10

Start Qty: 1.00

Date

Qty

Status

Required Date: 2/26/10

Required Qty: 1.00

We	arsł	100
we	arsi	10¢

D3564-5

Warehouse	Loc Oty	Loc Code	
Location			
OFFSHORE			
FG	2		
34806	2		
Main Warehouse			
FP19	40		
51925	1		T 5/10-3-2
54772	13		1 UK 10 3 X
55024	12		
55333	14		
Main Warehouse			
ST	2		
45824	1		
47433	1		

W/O:			WC	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A:	Date: _	
		esolution:							
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			, , <u></u>
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approvai
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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		·							
			1						

Work Order ID: 56137

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ Comments: IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Replacement Mfg/

Manufactured

Primary

Bin No

Last

Route 200

Unit of Each

Qty on

Remaining 668.0000 16.0000

Start Date: 2/10/10

Start Qty: 1.00

Qty

Date Status

Required Date: 2/26/10

Required Qty: 1.00

O-Ring, 205 Skidtube

Component Item ID/

D2594-3

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	527	
51613	27	
55546	500	
Main Warehouse		
ST	141	
52562	141	

1 Bl 10-3-2

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W/O:			W	ORK ORDER CHAN	GES			· •		
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCI	R: Yes	No DQ	A:	Date:	
	Res	solution:	Dispositio	n:	QA:	N/C CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Se Action Description Chief Eng	ection B	Sign & Date		cation ion C	Approval Chief Eng	Approval QC Inspector
					·				!	
										,

Work Order ID: 56137

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 2/10/10

Qty

Start Qty: 1.00

Required Date: 2/26/10

Required Qty: 1.00

Component Item ID/

Replacement Mfg/

Manufactured

Bin Primary No

Last

Route 200

Unit of Each

Qty on 705.0000 16.0000

Remaining

Date

Status

Plug, 205 Skidtube

D2594-1

Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse			
FP	577		
54008	1		
54643 /	15		
55002 🗸	561		16. bk10-3-2
Main Warehouse			,
ST	128		
42221	16		
42807	92		
43884	3		
46435	2		
51527	9		
51757	6		_

Dart A	Aeros	pace	Ltd
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W/O:			WC	ORK ORDER CHANG	iES	· · · · · · · · · · · · · · · · · · ·			
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A :	Date: _	
	Res	solution:						Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR	(1)			
DATE	STEP	Description of NC	Initial		ion B	Verific	cation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Sign & Date	Secti	ion C	Chief Eng	QC Inspector
					:				
								-	
						-	:		<u> </u>



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECK	ED APPROVED	DRAWING NO. REV. D
	* #	D2580 SHEET 1 OF 3
DATE		TITLE SCALE
07.0	2.27	205 SKIDTUBE ASSEMBLY NTS
Α	96.09.16	NEW ISSUE
В	96.12.02	AS MANUFACTURED
С	98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS INCLUDE DEO 9124/9183



QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	Х	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130	INSERT
į.	İ	or AKS7-1032-130	
		or AKS4-1032-130	
	ļ	or AELS-1032-130	
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP CARY

RETURNOUS

ENGINUTED SIGN

UNCONTROLLED SIGN

SUBJECT TO AMARIA A G

WITHOUT NOTICE

WORK CADER

NO. 54.27.

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:

SEE NOTES ON PAGE 2 FOR D2580-041 AND PAGE 3 FOR D2580-045

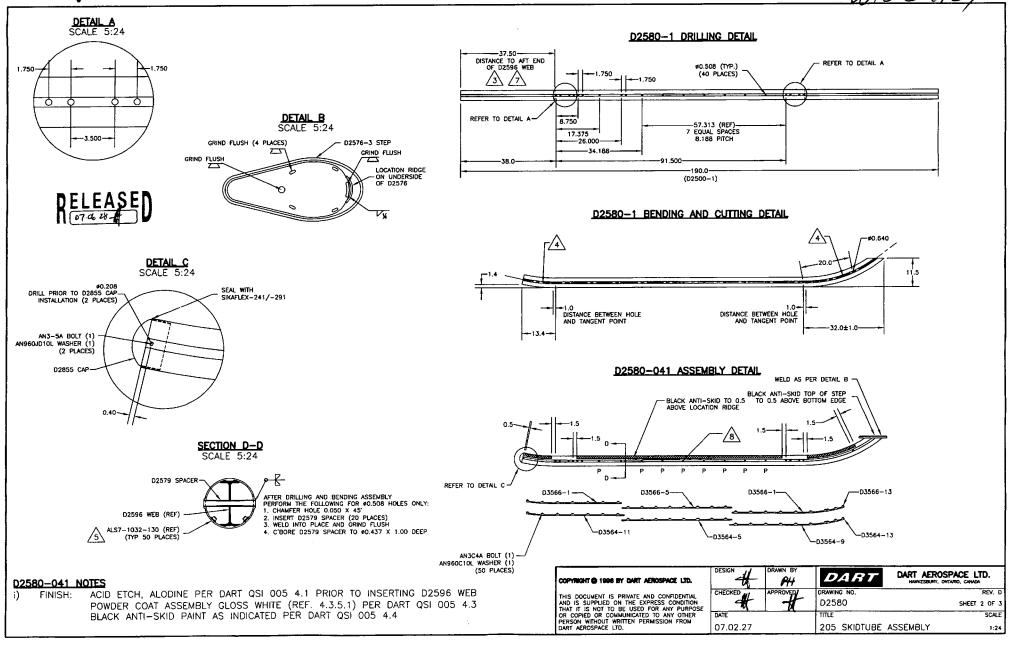
8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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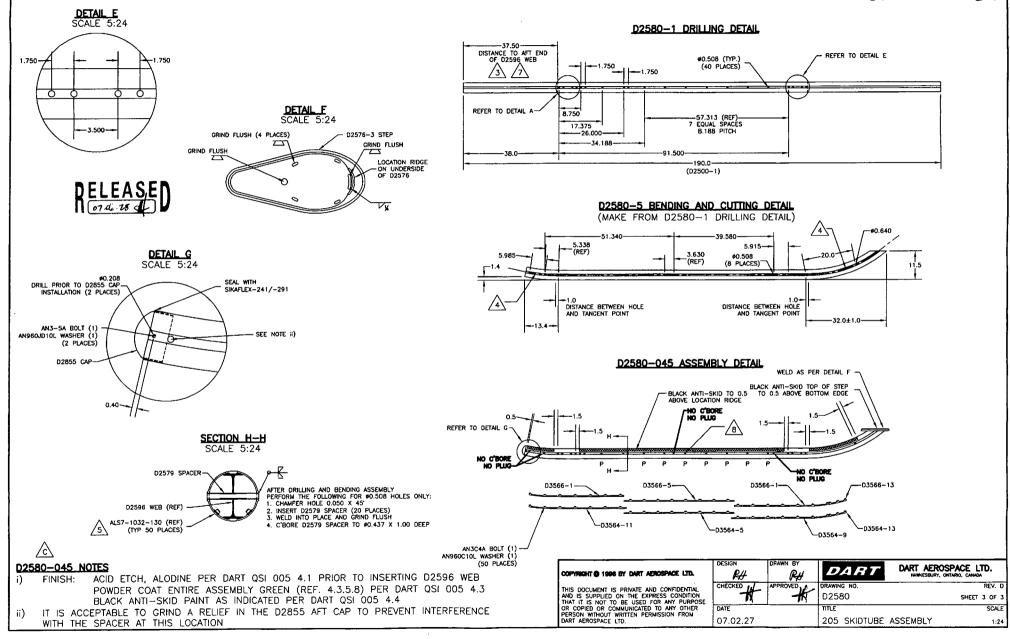
W/O:			WC	ORK ORDER CHANG	GES					
DATE	STEP	PR	OCEDURE CHA	DURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
				•						
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _		
Resolution:			Disposition	Disposition: QA			QA: N/C Closed: Date:			
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCF	l)		., .,		
DATE STEP	STEP	Description of NC		Corrective Action Section B			Verification		Approval	
	·	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Approval Chief Eng	QC Inspector	
 										

W/054/37



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W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
				QA: N/C Closed:					
NCR:				ER NON-CONFORMA					
DATE STEP	STED	Description of NC	Description of NC Corrective Action			Section B Verific			Approval
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Approval Chief Eng	QC Inspector

W/056137



Dart Aerospace Ltd W/O: **WORK ORDER CHANGES Approval** Approval DATE **STEP PROCEDURE CHANGE** By Qty Date Chief Eng / QC Inspector Prod Mar Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ___ Date: ___ Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification **STEP Approval** DATE **Approval** Sign & Initial **Action Description** Section A Section C Chief Eng QC Inspector Chief Eng Chief Eng Date

NO. Ade

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Bardon Elliett	
Job number: 50-184	
Part number: D205 634 041	
Description: 205 skid tube	
Welding Process: Tig[Mig[] Base materiel: Along a second	
Current: AC[DC[]	

TEST REQUIREMENTS AND RESULTS

Visual:	pass[/] fail[]
Penetration:	pass[] fail[]
UNACCEPTABLE	
Cracks:	pass[/ fail[]
Undercut:	pass[fail[]
Pin holes:	pass[4] fail[]
Overlap (cold lap)	pass[fail[]
Porosity (surface):	pass[/ fail[]
Coloration:	pass[fail[]
Qualifier (D)	Date of Test Coupon 10.02.23
Welder Bardan Ellipst	Date of Test Coupon 10-02-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld